

**Work Order ID 59201**

Friday, May 28, 2010 9:17:34 AM



Page 1

Item ID: D3564-9

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/27/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-5-28 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3564	Rev D

100



FLOW WATER JET

Waterjet

Memo

0.00

FB 10-6-9

FLOW CNC Waterjet

304 . 063

1-Cut as per Dwg D3564 \*\*\*\*\*(D3564-1F)\*\*\*\*\*  Dwg Rev: **D**  Prog  
Rev: **D**  2-Deburr if necessary

(13)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

FB 10-6-9

Memo

0.00

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

Swagelok

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

NC BRAKE

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

(13)

Brake NC

Memo

0.00

Brake NC

Deburr if necessary  Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155  Form Joggle as per Dwg D3564 on brake using Jig DT 8157

SP 10/06/15

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

Ensure joggle as per dwg D3429

SW 10/06/15

(X13)

150



Large Fab

0.00

Memo

0.00

Large Fab

Qty Description Batch  A/R  
 Weld hardcoat as per Dwg D3564

2059B Hardcoat

M114642

EZ 10-6-~~00~~ X13 15

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Page 3

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Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

S.10616

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S.10616

X/3

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 112588

Memo

0.00

START TIME:

3:25

OVEN TEMPERATURE:

320<sup>o</sup>

3:55

13 BL 10-6-16

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Page 4

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Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC3- Inspect Part Finish

0.00

41 10/06/10

13

8



QC

Memo

0.00

Quality Control

200

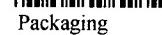
Identify as per dwg &amp; Stock Location:

FD-19

0.00

13

BL 10-6-10.



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

10/06/17



QC

Memo

0.00

Quality Control

MF 10-6-17

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NOTE: Date & initial all entries

# Picklist Print

Friday, May 28, 2010 9:17:38 AM

Page 1

Work Order ID: 59201



Parent Item: D3564-9



Parent Item Name: Wearshoe

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP Rev:A New Issue 07-03-08 ec

Start Qty: 12.00

IPP Rev:B As per Rev C 07-07-09 JLM

Required Qty: 12.00

IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of sf	Qty on 6.7443	Qty per Kit 1.41	Total 17.81053	Qty	Date	Status
M304S16GA													

304/316 Sheet .063



R10-6-9

Location	Loc Qty	Loc Code
MAT	6.74427	
111323	0	
114467	6.74427	

114799

114799

(3)

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	59201
Description: Wearshoe	Part Number:	D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>B</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-6-9	Date:	10/06/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	

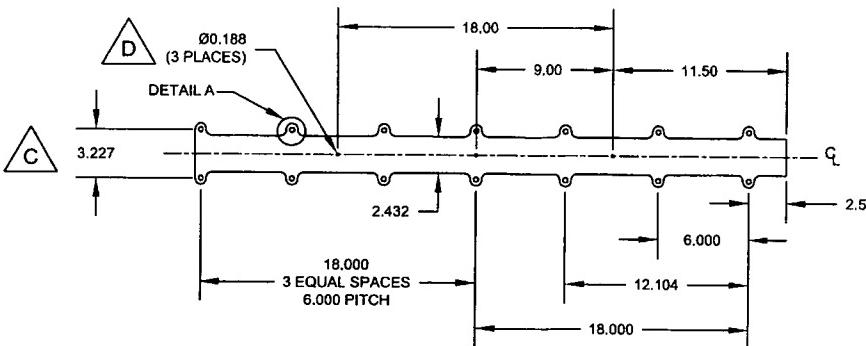
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

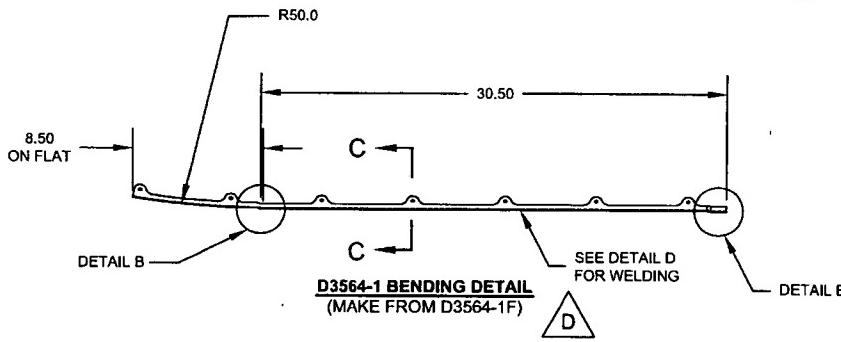
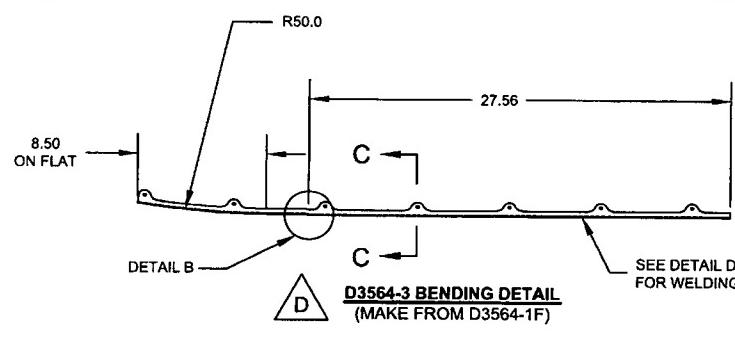
WORK ORDER

NO. 59201BS 10-5-28

RELEASED

07.09.04 #

D3564-1F FLAT PATTERN

D3564-1 BENDING DETAIL  
(MAKE FROM D3564-1F)D3564-3 BENDING DETAIL  
(MAKE FROM D3564-1F)

## D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT  $\zeta$

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3; D3564-1/3 WAS ONE FIGURE; PG2 A7,A3; D3564-9/11 WAS ONE FIGURE; PG2 A7,A3; D3564-9/11 WAS ON PG1; PG3 B8,C8; D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	SI	D3564	SHEET 1 OF 3
APPROVED	SI	TITLE	SCALE
DE APPR.	SI	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

D

C

B

A

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8

7

6

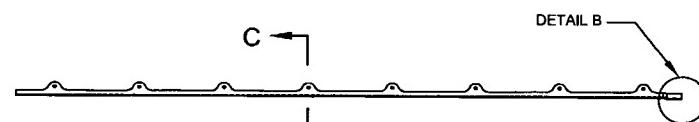
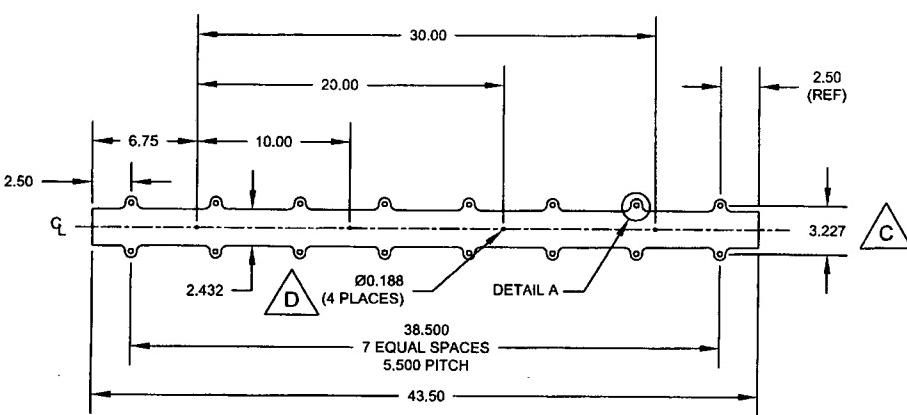
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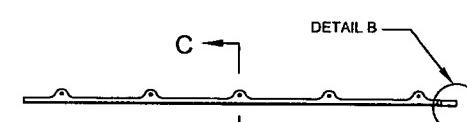
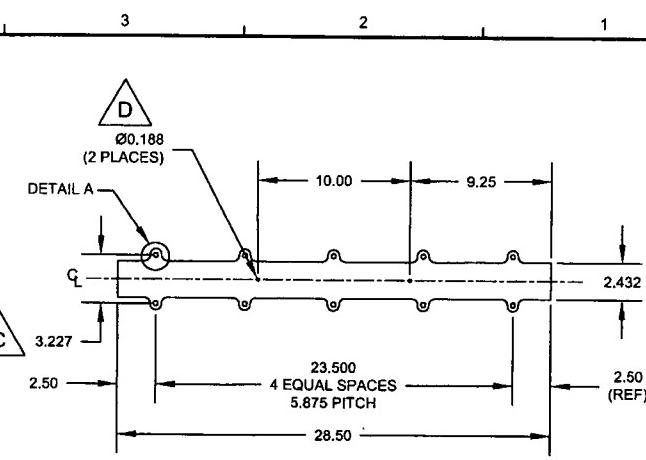
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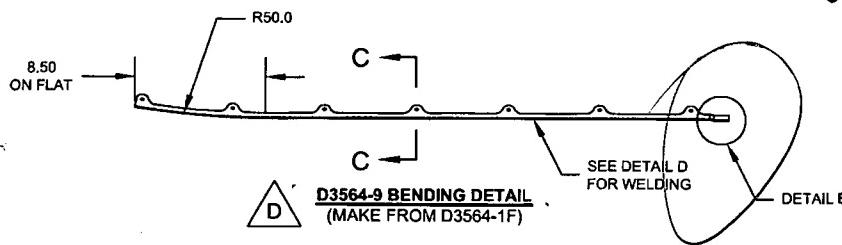


**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)

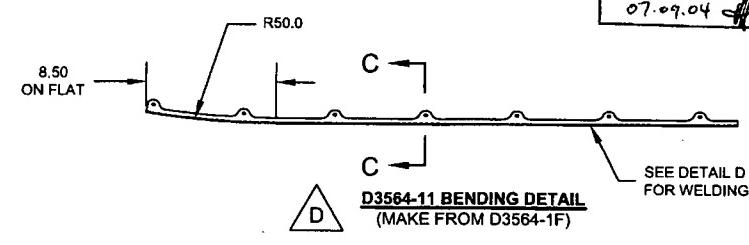
W1059201



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

**RELEASED**  
07-09-04

8

7

6

5

4

3

2

1

DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b>
DRAWN	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO.
MFG. APPR.	<i>SH</i>	D3564
APPROVED	<i>SP</i>	REV. D
DE APPR.	<i>SP</i>	SHEET 2 OF 3
DATE	07.08.21	TITLE
		WEARSHOE
		SCALE
		1:8

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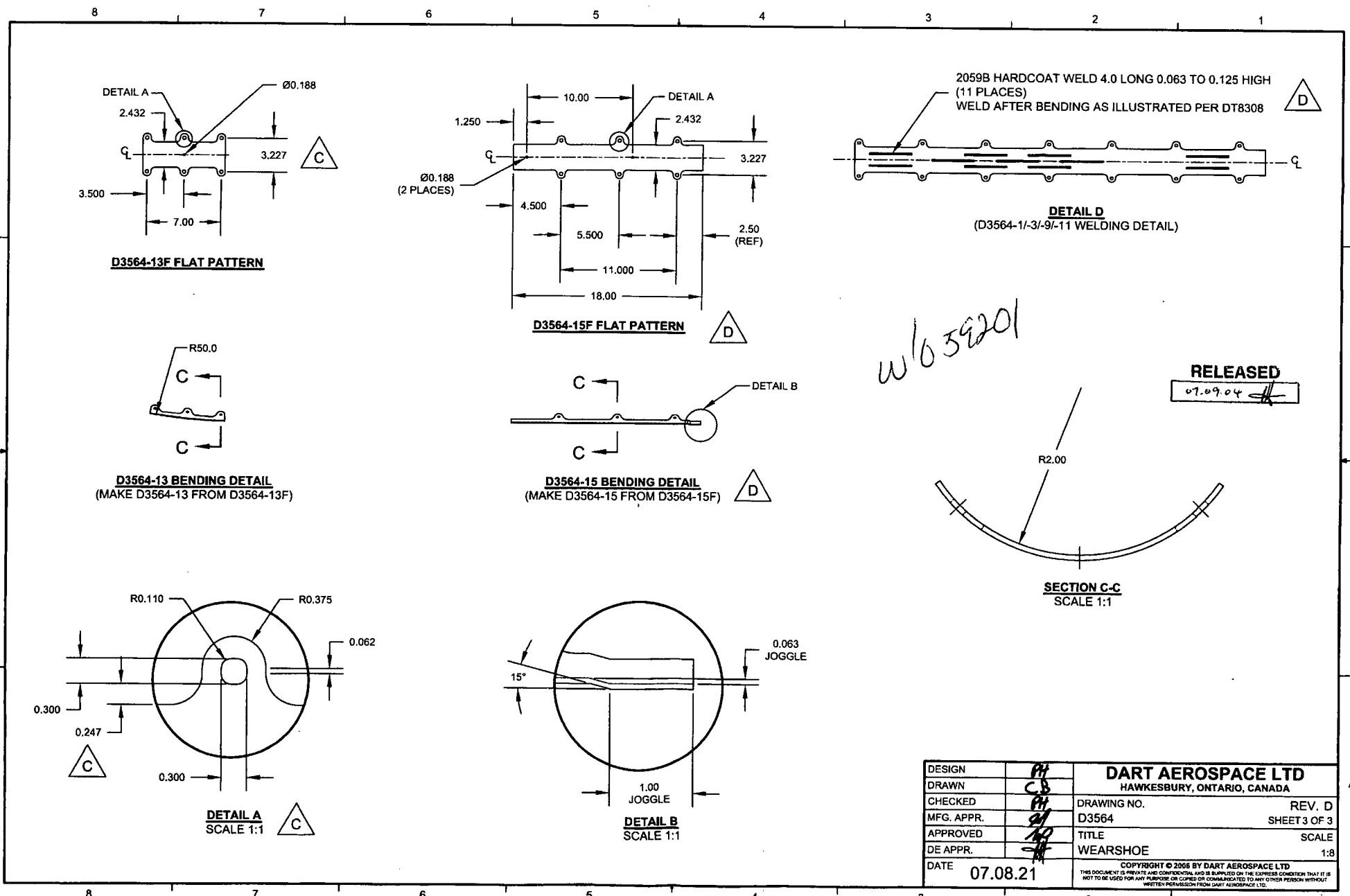
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